

Date: Friday, 28/11/2008 2:54:28 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LUG ASSEMBLY		
Job Number	: 43854			Part Number	: D27363		
Estimate Number	: 10012			Drawing Number	: D2736 REVA		
P.O. Number	:			Project Number	: N/A		
This Issue	: 28/11/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 10/12/2008 Qty: 10 Um: Each		
Previous Run	: 41598			Comment	: Est Rev:D Removed from 9 digit 05-10-25 JLM		
Written By	:						
Checked & Approved By	: <u>JUL 08/12/08</u>						
Comment							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2591	Lug, GHW Adapter	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)		
	Pick:		
	Qty Part Number Description Batch	<u>B39864</u>	<u>PL 8-12-5 x11</u>
2.0	D27353	Lug Bracket	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)		
	Pick:		
	Qty Part Number Description Batch	<u>B39866</u>	<u>PL 8-12-5 x11</u>
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
	Comment: LARGE FABRICATION RESOURCE 1		
	Weld D2591 & D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484		
	Steel Rod Batch: <u>D1108350</u>		<u>D 8-12-8 x11</u>
4.0	QC9	VISUAL WELDING INSPECTION	
	Comment: VISUAL WELDING INSPECTION		<u>A 08/12/08 61</u>
5.0	QC5	INSPECT WORK TO CURRENT STEP	
	Comment: INSPECT WORK TO CURRENT STEP		<u>S 08/12/08 610</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG ASSEMBLY

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M109152



IPX

Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 11:15

OVEN TEMPERATURE: 400

FINISH TIME: 11:45

400
01

M-A 08/12/09

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08 - 12 - 09

X14

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 76A FLOR

LSP/10 08/12/10 (1)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/11 P

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

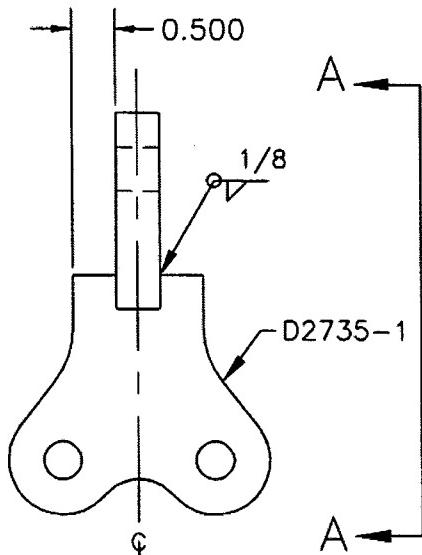
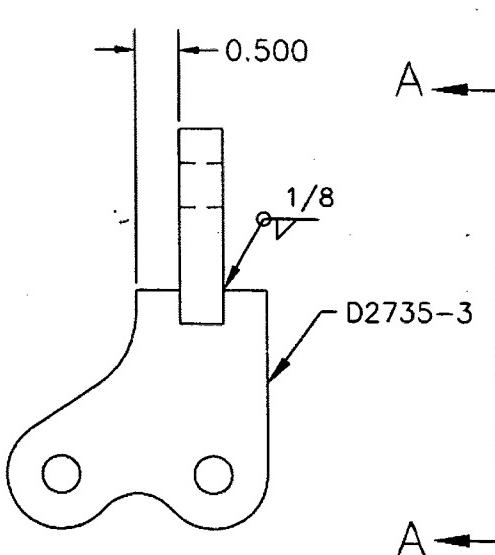
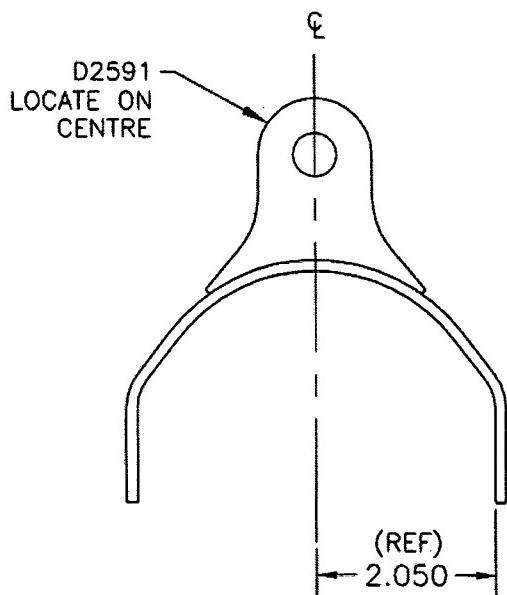
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>MAY</i>	DRAWN BY <i>MAY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>RE</i>	APPROVED <i>JF</i>	DRAWING NO. D2736
DATE 97.12.18		REV. A SHEET 1 OF 1
	TITLE LUG ASSEMBLY	SCALE NTS

A 97.12.18 NEW ISSUE

D2736-1 LUG ASSEMBLYD2736-3 LUG ASSEMBLYVIEW A-ANOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (Q)

RELEASED
 97/12/24 DS

ECN 057

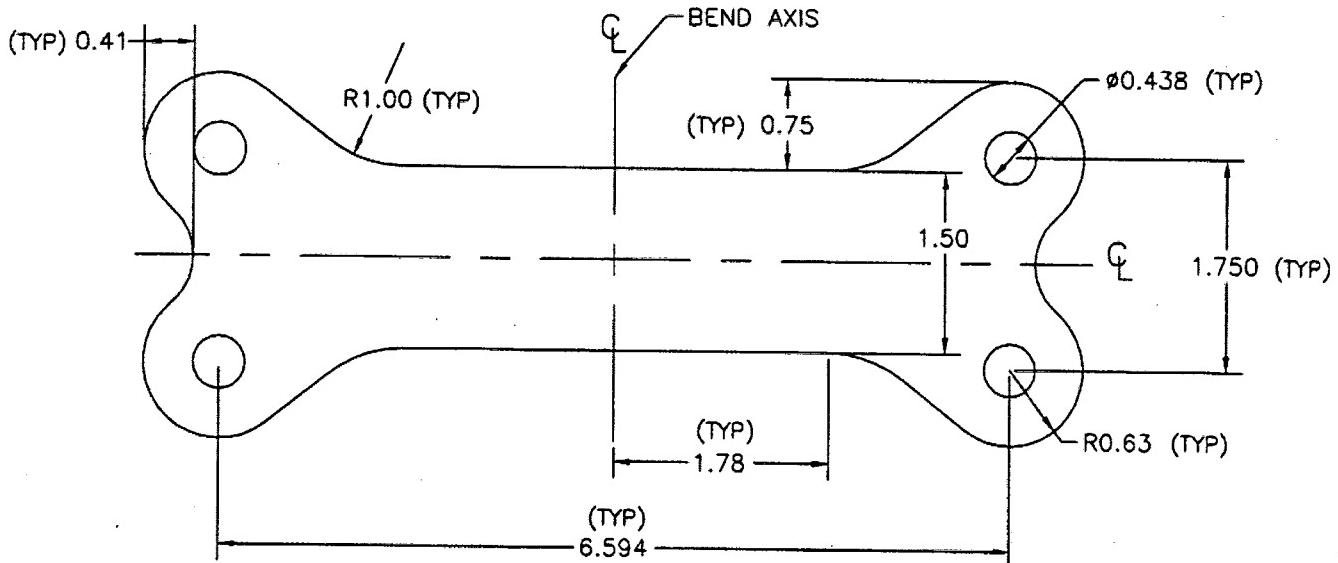
 SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO 43854

DART

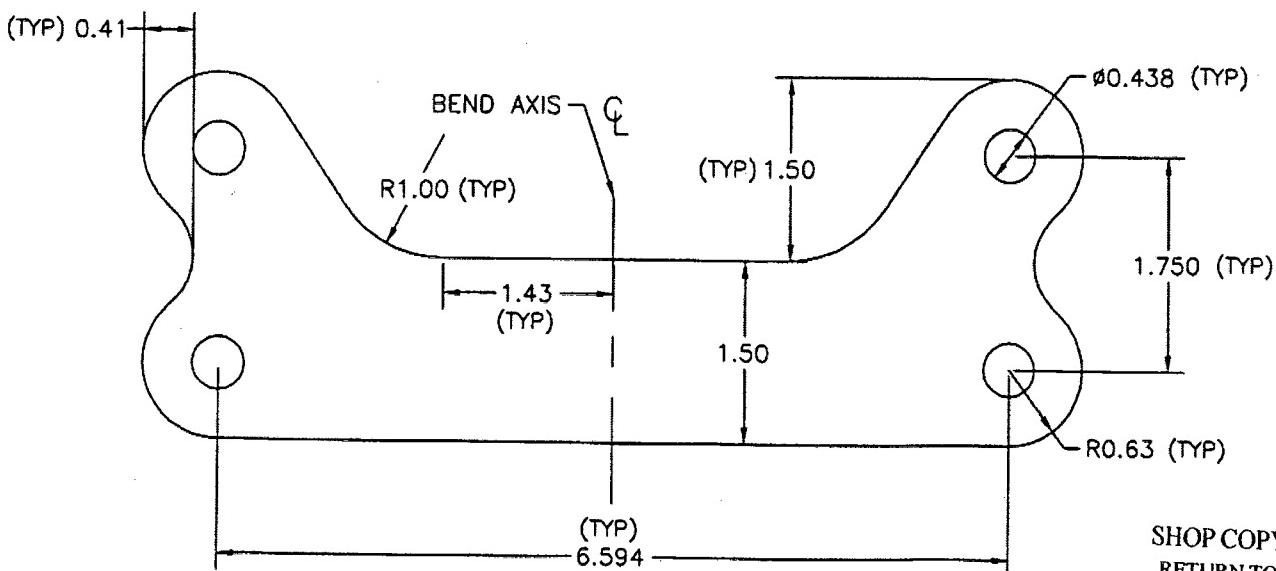
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>CP</i>	<i>KE</i>	D2735	SHEET 1 OF 2
DATE		TITLE	SCALE:
98.12.14		LUG BRACKET	2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED

98.12.14 DS



D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (C)

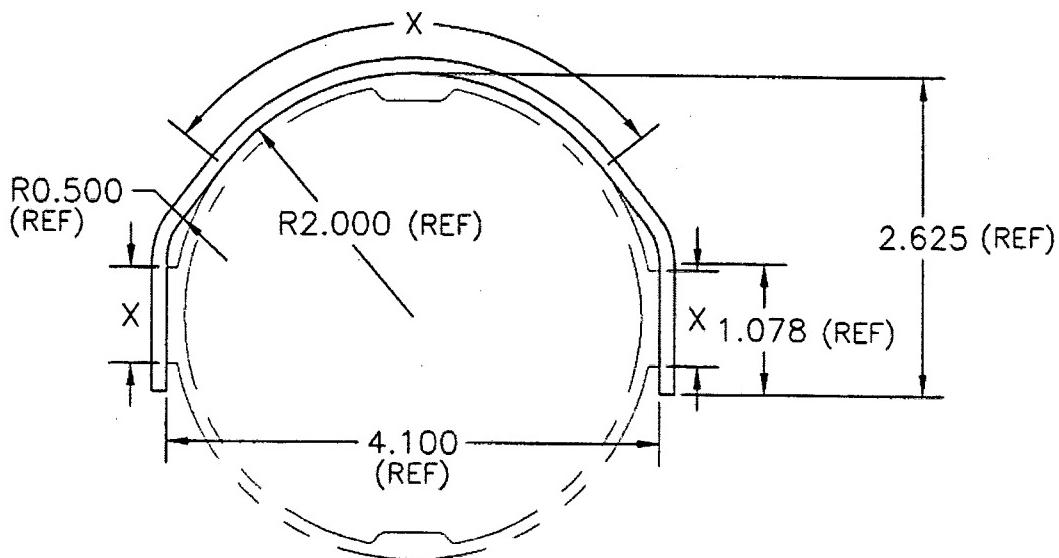


D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (C)

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WITHOUT NOTICE
WORK ORDER #
NO. 43859

DART

DESIGN <i>SH</i>	DRAWN BY <i>PA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735
DATE 98.12.14		REV. C SHEET 2 OF 2 TITLE LUG BRACKET SCALE 2:3

RELEASED
18.12.14 DSD2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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